

# Work Order ID 61443

Wednesday, August 25, 2010 10:32:06 AM



Page 1

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	8/25/2010	Start Qty:	1.00			
Required Date:	9/1/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10-8-25	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9445 jig								
	****cut cutouts with zip cut as per dwg D3832****								
	3- remove from jig and weld lable plate as per dwg D2989								
	A/R ER316 S.S. Rod Batch: 4113328								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

10/09/02 (k)

10.09.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Lid Assembly				Stop	
Start Date:	8/25/2010	Start Qty:	1.00			
Required Date:	9/1/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00							<i>1/100903</i>
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat Powder Coating	Memo 1- Plug holes prior to powder coating 2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989 1ST COAT: START TIME: <i>1:55</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>2:25</i> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00							<i>PRESSURE WASH ① BR 10-9-7. PTO →</i> <i>BR 10-9-7 ①.</i>

W/O: 61443		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-9-7	—	ADD SEQUENCE FOR PRESSURE WASH. <u>PERMANENT CHANGE SEQUENCE 125</u>	BR	10-9-7	①	U 10-9-7	S 10-9-7

Part No: D2989-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 25, 2010 10:32:06 AM

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Item ID: D2989-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid Assembly

Start Date: 8/25/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/1/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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131



HandFinish

Wing Walk as per dwg QSI005 4.4 Batch 1115028 0.00 7/10/09/08

Hand Finishing

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg  
A/R Spray paint black batch: 1115193

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

141



Packaging

Packaging

Identify as per dwg & Stock Location: G-A 0.00

Memo

0.00

W/O 614428/20/09/09 B8/20/09/09

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries


**Work Order ID 61443**

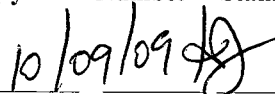
Wednesday, August 25, 2010 10:32:06 AM

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Item ID: D2989-041 Accept  Setup Start   
Revision ID:  
Item Name: Basket Lid Assembly Stop   
Start Date: 8/25/2010 Start Qty: 1.00  Cust Item ID:  
Required Date: 9/1/2010 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/09/09   
P110-9-09  
①

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Wednesday, August 25, 2010 10:32:10 AM

[illegible]

**RESEARCH DESIGN AND METHODS**

**Required Qty: 1.00**

**Comments:** IPP Rev:I Removed D2989-043 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	15.0000	2	2		10/08/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				15					
					60172			3					
					61091			12					
D2506  Label Plate		Manufactured	No			100	Each	1.0000	1	1		10/08/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				1					
					60272			1					
D2512-7  Rib		Manufactured	No			100	Each	6.0000	1	1		10/08/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
					59864			2					
					60669			4					

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 61443

Parent Item: D2989-041






Parent Item Name: Basket Lid Assembly

Start Date: 8/25/2010

Required Date: 9/1/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3833-3	Manufactured	No	100	Each	7.0000	2	2		<i>MY 10/09/01</i>												
Mesh (Lid End)																					
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td></tr><tr><td>WA</td><td>7</td><td></td></tr><tr><td>46308</td><td>1</td><td></td></tr><tr><td>60672</td><td>6</td><td></td></tr></table>										<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	WA	7		46308	1		60672	6	
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																			
WA	7																				
46308	1																				
60672	6																				
✓ D3836-041	Manufactured	No	100	Each	2.0000	1	1		<i>MY 10/08/31</i>												
Rib Assembly (Basket Lid, LH)																					
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td></tr><tr><td>WA</td><td>2</td><td></td></tr><tr><td>60917</td><td>2</td><td></td></tr></table>										<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	WA	2		60917	2				
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																			
WA	2																				
60917	2																				
✓ D3836-042	Manufactured	No	100	Each	2.0000	1	1		<i>MY 10/08/31</i>												
Rib Assembly (Basket Lid, RH)																					
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td></tr><tr><td>WA</td><td>2</td><td></td></tr><tr><td>60918</td><td>2</td><td></td></tr></table>										<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	WA	2		60918	2				
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																			
WA	2																				
60918	2																				
✓ D3852-041	Manufactured	No	100	Each	2.0000	1	1		<i>MY 10/08/31</i>												
Rib Assembly																					
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td></tr><tr><td>WA</td><td>2</td><td></td></tr><tr><td>60919</td><td>2</td><td></td></tr></table>										<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	WA	2		60919	2				
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																			
WA	2																				
60919	2																				
✓ D3852-042	Manufactured	No	100	Each	2.0000	1	1		<i>MY 10/08/31</i>												
Rib Assembly																					
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td></tr><tr><td>WA</td><td>2</td><td></td></tr><tr><td>60920</td><td>2</td><td></td></tr></table>										<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	WA	2		60920	2				
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																			
WA	2																				
60920	2																				

Wednesday, August 25, 2010 10:32:10 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

**RELEASED**  
08/11/18 MJP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 61443

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
  - 8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9-15; D3836-042 REPLACES D2989-10-15; D3838-041 REPLACES D2989-11-7; D3838-042 REPLACES D2989-2-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9-10 (NOW ON D3836 DWG); D2989-11-21-15 (NOW ON D3838 DWG) AND D2989-11-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED	443		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2989</b> TITLE <b>BASKET LID ASSEMBLY</b> COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
		REV. D	SHEET 1 OF 5
		SCALE	NTS

W/O:		WORK ORDER CHANGES					
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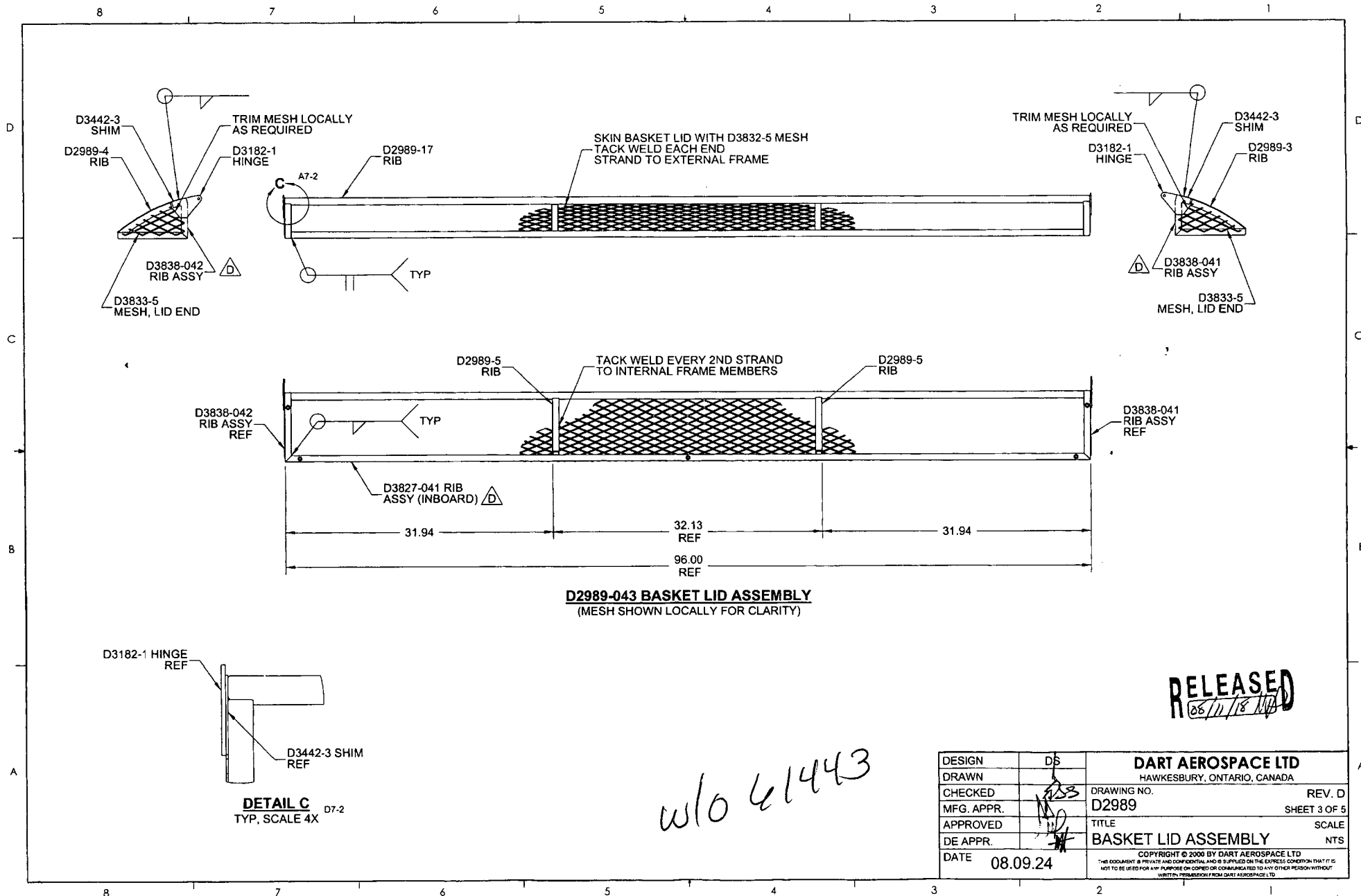
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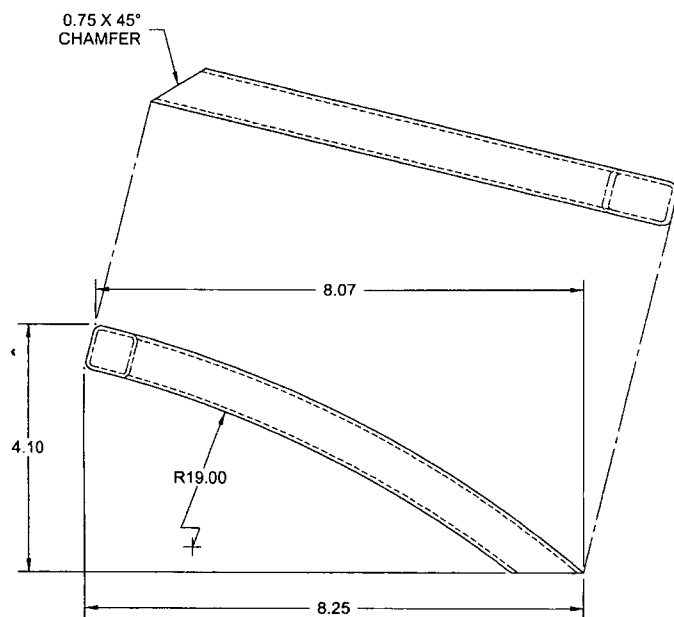
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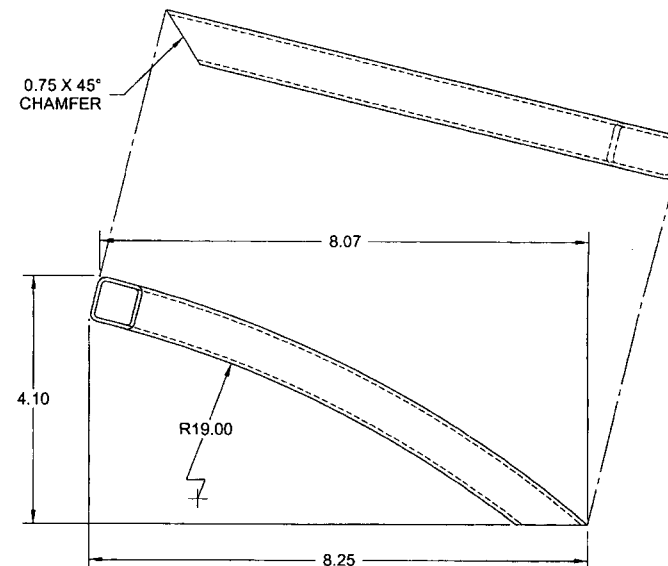
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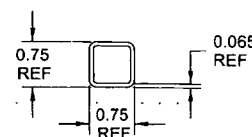
**NOTE:** Date & initial all entries



**D2989-3 RIB**



**D2989-4 RIB**



**TYPICAL SECTION  
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**RELEASED**  
04/11/18

W/C 61443

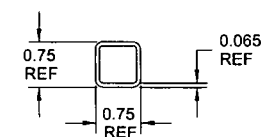
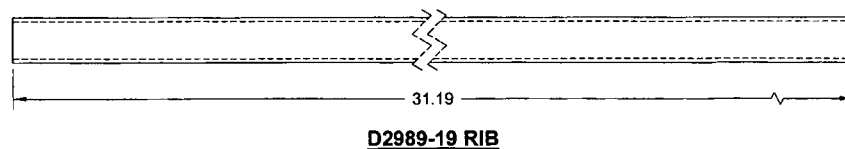
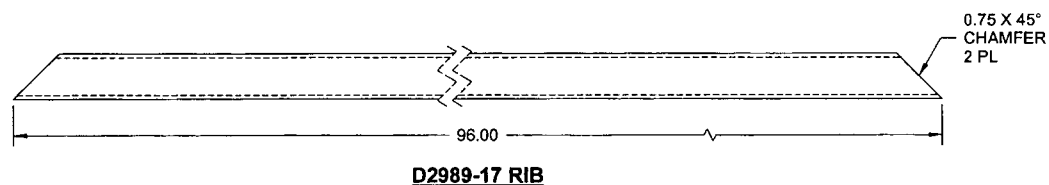
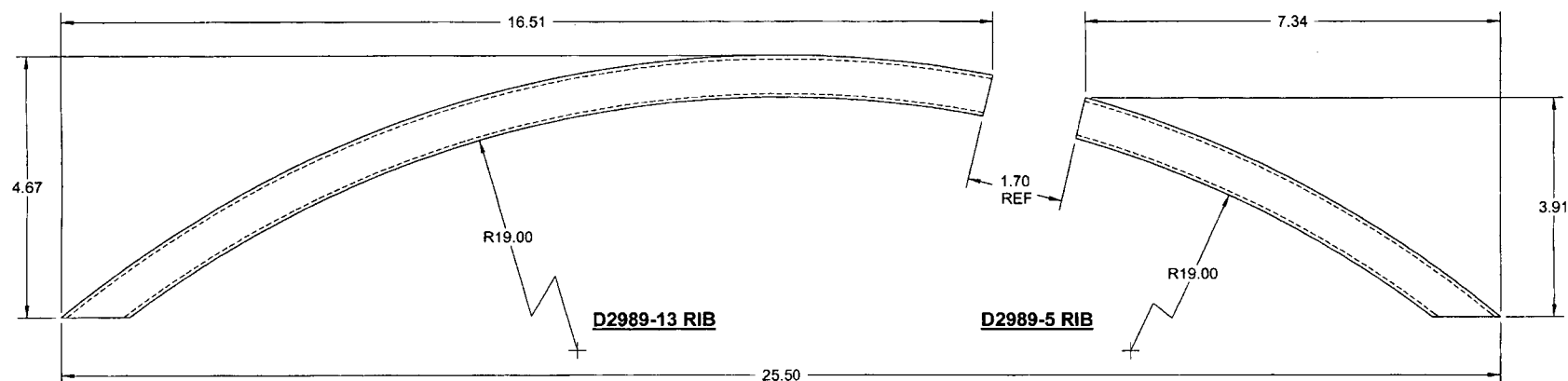
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



TYPICAL SECTION  
VIEW

w/o 61443

RELEASED  
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED	NTS	TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries